



Dart Aerospace Ltd.
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Canada

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D2957
Job Sheet 179850



Part No: D2957

Job Qty: 20 ea

Part Name: Mounting Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/25/18

Job Tracking No:

Due Date: 6/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP: C 00.08.09 New dwg rev B (mpp 2078) EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		6/26/18	0.00	0.00	Start Up Machining-1		DAS
100	Bandsaw	20 pcs		6/26/18	0.00	0.17	Bandsaw1		54
110	CNC Vertical Machining	20 pcs		6/26/18	0.04	5.41	HAAS1-2		9-89
130	QC	20 pcs		6/26/18	0.00	0.00	QC8 Machining-1		18/06/28
150	Packaging	20 pcs		6/26/18	0.00	0.00	Packaging3-1		Dr 2018-06-28
160	QC21-SA	20 Ea		6/26/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks 10.500" long 1 blank makes 5 parts

Descriptions: 110 - Machine as per folio FA042 Deburr

150 - *****STOCK IN BASKET CELL*****

JUN 28 2018
21
0330

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X01.250	6061-T6 Bar .500 X 1.25	3.5000 ft (.175 ea)	90-Start up Operation	5036061

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X01.250	4	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Plate	0.250Inches $\pm$ 0.030	0.280 0.220		
2	Mounting Plate	0.068Inches $\pm$ 0.010	0.078 0.058		
3	Mounting Plate	0.323Inches $\pm$ 0.010	0.333 0.313	Diameter	
4	Mounting Plate	0.250Inches $\pm$ 0.010	0.260 0.240		
5	Mounting Plate	1.060Inches $\pm$ 0.030	1.090 1.030		
6	Mounting Plate	0.875Inches $\pm$ 0.010	0.885 0.865		
7	Mounting Plate	0.449Inches $\pm$ 0.010	0.459		

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved	☐ Skid-tube ☐ Machining ☐ Thermofforming ☐ Large Fab	☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite	☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier	AGAINST DEPARTMENT/PROCESS			
					☐ Engineering ☐ Quality ☐ Other			

Date :	Step #:	QTY Effective :	MRB (QS1042) Approval
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Description Work Order Deviation	Disposition
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Completed By	Lead hand / Supervisor	Approval Verification	QC / QA Coordinator	Approval
Revision: Inspector: Exp Date: Instructions: Part: D2957 Job No: 179850 Serial No/Batch: S083647 Container No: S083647 DART AEROSPACE Date: 06/25/18				

Root Cause		OTHER :	
☐ No Re-verification	☐ Operator	☐ Pressure/Forced	☐ Bending
☐ Offset/Setup	☐ Supplier	☐ Centre Not Concentric	☐ Cracks
☐ Training	☐ Use for Testing	☐ Cuffs	☐ Crimp/Kink/Ripple/Wave
☐ Poor Information	☐ Rushing	☐ Crushing	☐ Heat Treat
☐ Product Improvement	☐ Process Improvement	☐ Wave/Twist in Tube	☐ Marks/Chatter
☐ Manufacturing Process	☐ Past Due	☐ Instructions Incomplete/Unclear	☐ Drill Holes
☐ Misidentified	☐ Past Expiry Date	☐ Cut Too Short	☐ Countersink
☐ Substation	☐ LOA	☐ Corrosion	☐ Ins
☐ Tribal Knowledge	☐ Internal Transport	☐ Out of Sequence	☐ Wrong Stock Pulled
☐ Material	☐ Equipment/Tooling	☐ Mislabeled	☐ Fit/Function
☐ Handling/Pre	☐ Doc/Data	☐ Off-set	☐ Misaligned/off center
☐ Design	☐ Design	☐ Drawing	☐ Part Moved
☐ Environment	☐ Design	☐ Part Lost/Missing	☐ Part Incorrect
☐ Design	☐ Design	☐ Over/Under tolerance	☐ Outside Dimensions
☐ Design	☐ Design	☐ Positioned Wrong	☐ Turning Sequence

			0.439	
8	Mounting Plate	0.120Inches $\pm$ 0.030	0.150 0.090	Radius
9	Mounting Plate	1.850Inches $\pm$ 0.030	1.880 1.820	
10	Mounting Plate	0.250Inches $\pm$ 0.010	0.260 0.240	
11	Mounting Plate	0.190Inches $\pm$ 0.030	0.220 0.160	
12	Mounting Plate	0.125Inches $\pm$ 0.010	0.135 0.115	

Plex 6/25/18 7:38 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

